



Dart Aerospace Ltd.
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Canada

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D4931-5

Job Sheet 181983



Part No: D4931-5

Job Qty: 5 ea

Part Name: Engine Fitting (for B3e models)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/15/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Machining-3		
100	Doosan	5 pcs	8/31/18	8/31/18	0.78	4.35	Doosan		
110	QC	5 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-3		
112	Mill Conv	5 pcs	8/31/18	8/31/18	0.00	2.07	Mill Conv 1		
115	QC	5 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-3		
120	QC	5 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-3		
130	Packaging	5 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		
140	QC21-SA	5 Ea	8/31/18	8/31/18	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210

Descriptions: 112 - DRILL HOLES AS PER REQUIRED

SEP 25 2018
SEP 25 2018
DAS 21 9:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	.7500 ft (5 ea)	90-Start up Operation	508010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	1	36	0

Part Specifications

Specifications could not be found.

Plex 8/15/18 10:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD		Work Order: 181983
Description: EAPS P2 Engine Fitting		Part Number: D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	1 1/16-12			wire and nut	
37°	+/-0.5°	36.5°				
0.185	+/-0.010	.184				
0.315	+/-0.010	.314				
0.424	+/-0.010	.423				
0.250	+/-0.010	.251				
0.938	+/-0.010	.945				
1.927 Ref	+/-0.010	1.932				
0.25	+/-0.030	.255				
0.13	+/-0.030	.131				
0.907	+/-0.010	.906				
0.078	+/-0.010	.081				
Ø0.063	+0.004/-0.001	.062				
0.13 x 45°	+/-0.030 x +/-0.5°	.13 x 45°				
0.34	+/-0.030	.35				
0.25	+/-0.030	.255				
Ø0.238	+0.005/-0.001	.241				Vernier ID .05
35°	+/-0.5°	34.5°				
0.532	+/-0.010	.527				
1.063	+/-0.010	1.061				
0.513	+/-0.010	.513				Vernier ID .05
0.749	+/-0.010	.746				
1.025	+/-0.010	1.026				Vernier ID .05

Measured by: JMK/DreC	Audited by: G.A.	Preliminary Approval:
Date: 18/09/20	Date: 18-09-24	Date:
Rev	Date	Change
A	14.06.24	New Issue
		Revised by: KJ
		Approved:

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

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 Cambridge, ON K4A 1K7
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 www.dartaerospace.com

Container No: S111729
 Part: D4931-5
 Job No: 181983
 Serial No/Batch: S111729
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 09/20/16

FAULT CATEGORY

effect	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
lete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Mislabeled	☐ Finish
plete/Unclear	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence